



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2332-041
Job Sheet 185255



Part No: D2332-041

Job Qty: 4 ea

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/2/18	0.00	0.00	Start Up Small Fab		SmB
100	Small Fab	4 pcs		11/2/18	0.32	1.25	Small Fab		SmB
110	Brake NC	4 pcs		11/2/18	0.00	0.46	Brake NC 3		SmB
120	Small Fab	4 pcs		11/2/18	0.00	1.25	Small Fab		SmB
130	QC	4 pcs		11/2/18	0.00	0.00	QC5		12
140	Large Fab	4 pcs		11/2/18	0.00	1.00	Large Fab 1		13C
150	QC	4 pcs		11/2/18	0.00	0.00	QC9		EL
160	QC	4 pcs		11/2/18	0.00	0.00	QC5		EL
170	Small Fab	4 pcs		11/2/18	0.00	1.25	Small Fab		SmB
180	QC	4 pcs		11/2/18	0.00	0.00	QC5		38
190	Packaging	4 pcs		11/2/18	0.00	0.00	Packaging3		21 18-11-12
200	QC21-SA	4 Ea		11/2/18	0.00	0.00	QC21		21 NOV 14 2018

Part Op 100 - 1- Cut D2332-7 and D2332-5 to lenght as per dwg D2332. 2- Cut D2332-11 using 1/2" S.S tubing 7.735" long. 3- Descriptions: Deburr.

110 - Punch and form D2332-11 to lenght as per dwg D2332 using DT8012 (need 2 per ass'y)

120 - 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no foreign objects inside tube

140 - Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y) *****ensure nothing is inside of tube before welding***** S.S Rod batch: _____

170 - 1- Tumble 2- Assemble as per dwg D2332

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.250	304 SS Round bar .250	.4000 ft (.1 ea)	90-Start up Operation	m135249
M304TR1.000W.049	304 Round Tube 1.00 X .049W	1.7200 ft (.43 ea)	90-Start up Operation	m135250
M304TR0.500W.035	304 Round Tube .500 X .035W	5 ft (1.25 ea)	110-Brake NC	3082238
AN4-4A	Bolt ST340	4 Ea (1 ea)	170-Small Fab	5104458
MS21042L4	Nut ST303	4 Ea (1 ea)	170-Small Fab	5081390
NAS1149D0416J	Washer G9019	12 Ea (3 ea)	170-Small Fab	m131511-1 3094597

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

90-Start up Operation

M304R0.250

0

12

0

M304TR1.000W.049

2

4

0

110-Brake NC

M304TR0.500W.035

5

212

0

170-Small Fab

AN4-4A

4

34

0

MS21042L4

4

3,633

0

NAS1149D0416J

12

2,113

0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lid Prop Assembly	5.000Inches $\pm$ 0.030	5.030 4.970		
2	Lid Prop Assembly	1.250Inches $\pm$ 0.010	1.260 1.240		
3	Lid Prop Assembly	6.690Inches $\pm$ 0.010	6.700 6.680		

Plex 10/24/18 11:23 AM Dart.lajeunesse.marie

DART
AEROSPACE

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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S122096



Part: D2332-041

Job No: 185255

Serial No/Batch: S122096

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/30/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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